

Claims

1. Method for machining of a surface (31) of a roll in a twin-wire press (2), said twin-wire press comprises lower rolls (4, 6, 8, 25'), an endless lower wire (10) that runs in a path around the lower rolls, upper rolls (14, 16, 18, 25''), an endless upper wire (12) that runs in a path around the upper rolls, and the roll surface of said rolls comprises a coating (32), **characterised in that:**
 - 10 - an apparatus (50) having a movable machining tool (54) for machining of the coating (32), which apparatus comprises means (68) for removal of cut material from the coating (32), is arranged in connection to a space between one of said wire (10, 12) and roll (4, 6, 8, 14, 16, 18, 25', 25'') respectively,
 - 15 - the machining tool (54) of the apparatus is moved, from a rest position in connection to said space at the twin-wire press, in contact against the surface (31) of the roll for cutting of the coating (32) to a desired level during rotation of the roll (4, 6, 8, 14, 16, 18, 25', 25'') during removal of cut material during machining, and
 - 20 - the machining tool (54) is brought back to the original rest position when the cutting of the coating (32) to desired level has been achieved.
- 25 2. Method according to claim 1, **characterised in that** the machining of the coating (32) is performed at an end area (30) of a roll (4, 6, 8, 14, 16, 18, 25', 25'').
- 30 3. Method according to claim 1 or 2, **characterised in that** the machining of the coating (32) is done continuously during operation.

4. Method according to any of the preceding claims, **characterised in** that cutting is done by movement of the machining tool (54) axially along the roll (4, 6, 8, 14, 16, 18, 25', 25'').

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5. Method according to any of the preceding claims, **characterised in** that machining is achieved by milling.

6. Method according to claim 5, **characterised in** that the machining tool (54) is operated by compressed air.

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7. Method according to any of the preceding claims, **characterised in** that machining is carried out of the coating (32) on drive rolls (4; 14).

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8. Method according to any of the preceding claims, **characterised in** that machining is carried out on rolls (4, 14) involved in a press nip (4, 14).

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9. Apparatus (50) for machining of a surface (31) of a roll in a twin-wire press (2), **characterised in** that the apparatus (50) comprises a support (52) intended, at least during the machining, to be stationary arranged in connection to a space between a roll (4, 6, 8, 14, 16, 18, 25', 25'') and a wire (10, 12) at said twin-wire press (2), the apparatus (50) further comprises a movable machining tool (54) arranged to the support (52) for machining of a coating (32) of said surface (31) of the roll and that the apparatus (50) further comprises means (68) for removal of cut material from the coating (32) during the machining.

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10. Apparatus according to claim 9, **characterised in that** the machining tool (54) is arranged on a slidably and displaceable arm (56) journalled in bearings.

5 11. Apparatus according to claim 10, **characterised in that** the machining tool (54) is pivotally arranged in a first end (55) of the arm (56).

10 12. Apparatus according to claim 9-11, **characterised in that** the displaceable arm (56) is arranged slidably matched and displaced in a sleeve (58) that is arranged to the support (52).

15 13. Apparatus according to claim 12, **characterised in that** said sleeve (58) is displaceable arranged to the support (52) for adjustment of the level of height of the machining tool (54) above the surface (31) of the roll.

20 14. Apparatus according to claim 9-13, **characterised in that** the apparatus (50) comprises a screw bar (60) arranged at the support (52), a connection member (62), arranged between the screw bar (60) and the arm (56), which is fixed to another end (57) of the arm, and which connection member (62) is movably displaceable along the screw bar (60) during rotation of the screw bar, such that the arm is moved in said sleeve (58).

25 15. Apparatus according to claim 9-14, **characterised in that** the machining tool (54) is a milling cutter, suitably a shank end mill.

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16. Apparatus according to claim 15, **characterised in that** the milling cutter is operated by compressed air.

17. Twin-wire press (2) for dewatering of a fibre suspension, comprising lower rolls (4, 6, 8, 25'), an endless lower wire (10) that runs in a path around the lower rolls, upper rolls (14, 16, 18, 25''), and an endless upper wire (12) that runs in a path around the upper rolls, and said rolls (4, 6, 8, 14, 5 16, 18, 25', 25'') comprises a coating (32), **characterised in** that it comprises an apparatus (50) according to any of the claims 9-16.